

Work Order ID 147341-2

Wednesday, June 08, 2016 2:55:53 PM

147341

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Item ID: D3245-1

Revision ID:

Item Name: Panel

Start Date: 6/30/2016

Required Date: 7/8/2016

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Start Qty: 4.00 *4*
Req'd Qty: 4.00 *4*

Approvals: Process Plan: MLJ Date: JUN 1 0 2016

QC: _____ Date: _____ Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3245	D								

100 *100* FLOW WATER JET 0.00

Waterjet
FLOW CNC Waterjet

Memo 0.08
1-Cut as per Dwg D3245 ****prog.D3245-1/-2****

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

PR 2016/06/30

8

DAS
50
0.89

110 *110* QC2- Inspect parts off machine FAI/FAIB 0.00

QC
Quality Control

Memo 0.01

8

PR 2016/06/30

DAS
50
0.89

1-1272

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Page 2

Item ID: D3245-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Panel

Start Date: 6/30/2016 Start Qty: 4.00 ***4***Required Date: 7/8/2016 Req'd Qty: 4.00 ***4***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01							DAS 38 9-89 JUL 22 2016
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- C'sink as per Dwg D3245 2- Form D3245-1 as per Dwg D3245 Identify as D3245-1	0.01 0.12			DAS 30 9-89				JUL 28 2016 17/01/23 DAS 36 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01							DAS 38 9-89 JAN 23 2017

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[illegible]

Picklist Print

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Page 1

Work Order ID: 147341

147341

Parent Item: D3245-1

D3245-1

Parent Item Name: Panel

Start Date: 6/30/2016

Required Date: 7/8/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.07.07New issueKJ/JLM
IPP Rev:b ECN 1052 07-10-31 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	122.7750	0.804	5.385203	4.824		
M304S22GA									**				
304/316 .032 Sheet													

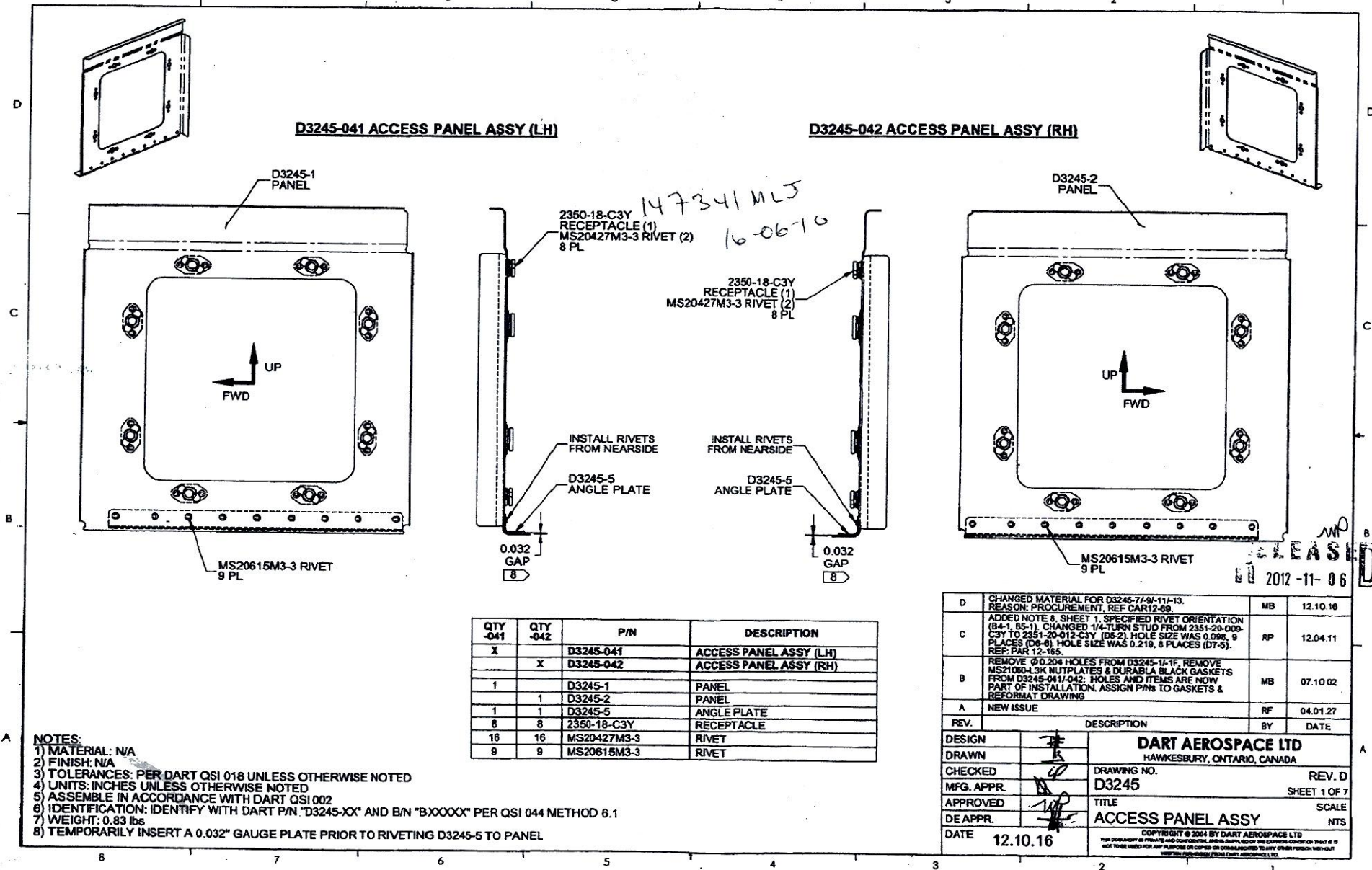
DR 2016/06/30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	122.775	
m126593	28.475	
m131999	30.3	
m134399	64	

6.2

D3245-041 ACCESS PANEL ASSY (LH)

D3245-042 ACCESS PANEL ASSY (RH)



D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL

8.00
REF

8.00 REF

D3245-7 GASKET
REF

INSTALL D3245-7
GASKET ON THIS SIDE
6

D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

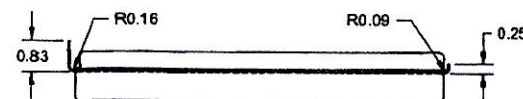
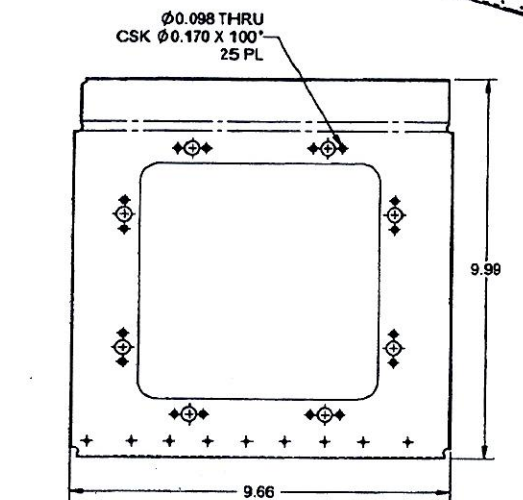
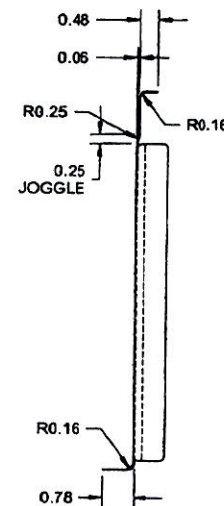
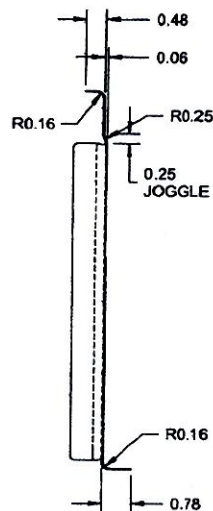
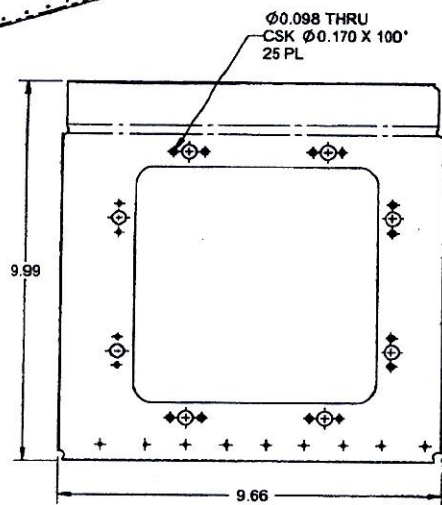
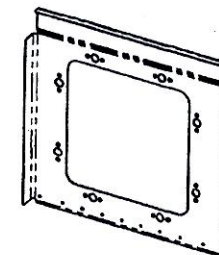
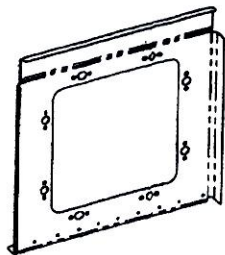
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.74 lbs

RELEASED
2012-11-06
WPD

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D3245	REV. D
MFG. APPR.	JP	SHEET 2 OF 7	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ACCESS PANEL ASSY	
DATE	12.10.16	NTS	

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D3245-1 PANEL (LH)

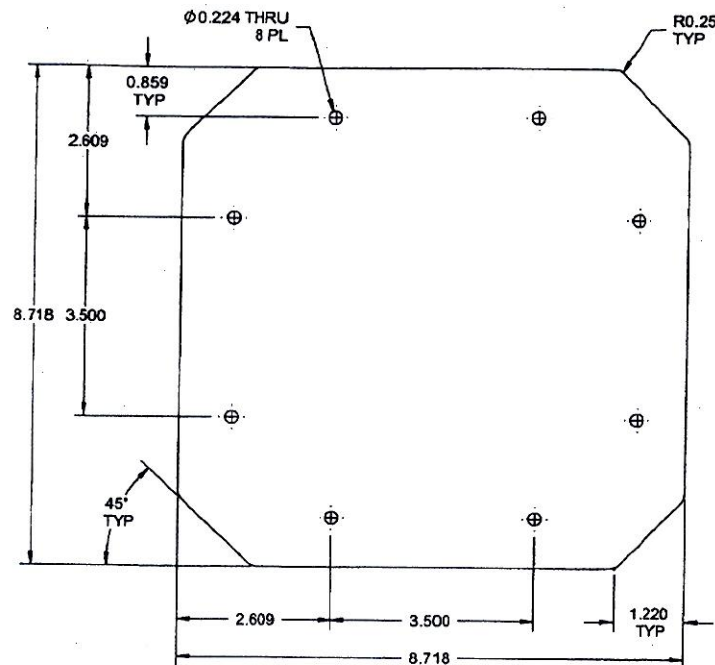
D3245-2 PANEL (RH)

- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

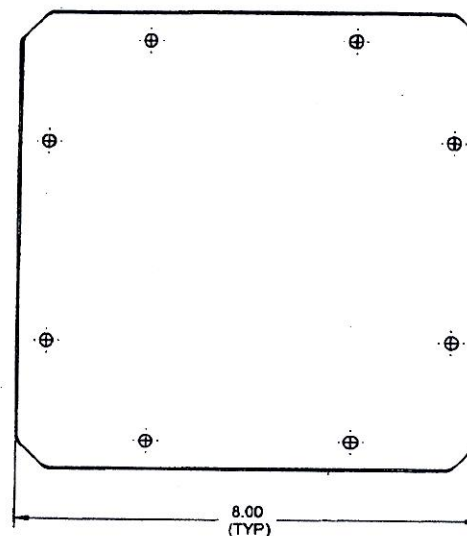
DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3245	SHEET 3 OF 7
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DE APPR.		ACCESS PANEL ASSY	NTS
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2012-11-06

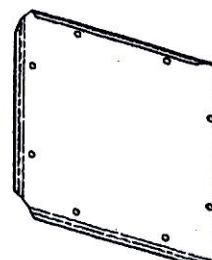
8 7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN



**D3245-3 DOOR
(MADE FROM D3245-3F)**



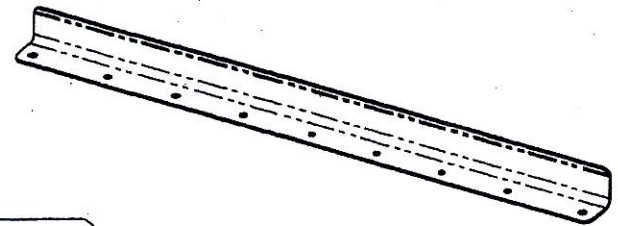
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

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2012-11-06

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MFG. APPR.		D3245	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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8 7 6 5 4 3 2 1

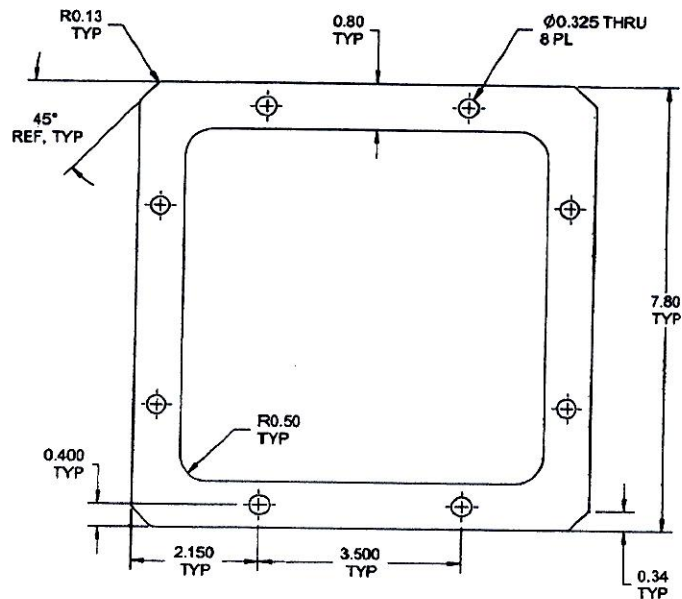


Technical drawing of a 19° REF. part. The drawing shows a cross-section of a component with a 19° angle. Dimensions include 0.065, 0.100, 0.57, and a typical radius of R0.09.

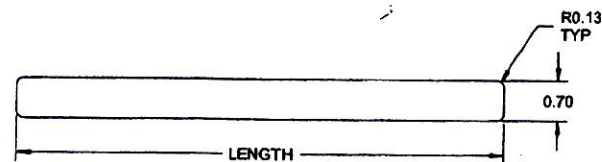
RELEASE
2012-11-06

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.08 lbs

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MFG. APPR.		D3245	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	
DATE	12.10.16	NTS	



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

RELEASE
2012-11-06
JMP

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3245 REV. D
MFG. APPR.		SHEET 7 OF 7
APPROVED		TITLE ACCESS PANEL ASSY SCALE NTS
DE APPR.		
DATE	12.10.16	

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